

Work Order ID 65590

Thursday, January 20, 2011 10:21:55 AM



Page 1

DRAB GREEN

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/10/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *MF* Date: *11-01-20* Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580	Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

1 0 BE 11/23/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

1

6

BE 11/03/08

130

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

DP

11-3-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004
A/R□□□ Aluminum Rod

m116577 BE 11/03/08
DP 11-3-9

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimension.

BE 11-03-10

Ph →

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

BB

11/03/10

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Sulor 111

FD

NCR11-514

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: _____ Fault Category: Eng - design NCR: Yes No DQA: ✓ Date: 11/03/28
 Resolution: rework Disposition: rework QA: N/C Closed: ✓ Date: 11/03/28

NCR: <u>65590</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/14	140	Found that the cross bolt spacers have cracks in them. Some large + some small Process (Swagging) R.C. Design: x-bolt wall too thick for swagging.	DP 11.03.22 DS/042	→ Pull out + remove cracks + bolt spacers holes - REPLACE #3,6,7,16,18,19 FROM AFT END WITH .049 WALL D 4202-1 B 6730B (x6)	DP 11-315 BB 11/03/16	S... 11/03/17	DP 11.03.22 DS/042	S 11/03/14

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ - Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

no cracks

8/10/14
8/10/17

10

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 BR 11-3-17

185

Drab Green(Ref:4.3.5.11)per QSI005 4.3 (Alum)

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

M104476
3:35
350°
4:05

1 BR 11-3-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 6 22 11/03/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 2/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1116040
Sikaflex expire date: 4/6/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1116040
Sikaflex expire date: 11/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 1116040

1 0 21 4/03/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 65590

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Item ID: D205-634-041

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Start Date: 1/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 uloz/22

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

①

220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev: _____

PPD 67/11

11/3/22 ①

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/22

MF

11-03-22

Picklist Print

Thursday, January 20, 2011 10:21:50 AM

Page 1

Work Order ID: 65590

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 Spacer		Manufactured	No			140	Each	106.0000	20	20		BE 11/03/10	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				106				B6621	
					64608			106				B66929	
D2580-1 205 Skidtube bent detail		Manufactured	No			110	Each	2.0000	1	1		BE 11/03/04	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				1				B 65509	
					63051			1					
				ST046				1					
					59856			1					
D2576-3 Step (maching detail)		Manufactured	No			140	Each	62.0000	1	1		BE 11/03/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				62					
					46661			14					
					52215			48					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 65590

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

D2855 *drab green* Manufactured No
Cap

200 Each 54.0000 1 1



yl 11/03/21

Location	Loc Qty	Loc Code
FP6	3	
56613	1	
63634	2	
ST026	51	
50513	1	
50770	28	
51539	2	
53791	20	

B65519

yl

AN3-5A Purchased No
Bolt

200 Each 1,085.000 2 2



yl 11/03/21

Location	Loc Qty	Loc Code
ST350	1085	
115016	385	
115371	500	
116632	200	

v2

AN960JD10L NAS1149D0332J Purchased No
Washer

200 Each 0.0000 2 2



1117010 (v2) yl 11/03/21

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
18/2/22							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 65590

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

1,628.000

50

50



Insert



21 11/03/21

Location

Loc Qty

Loc Code

FP

689

115079

689

ST282

939

113238

17

115502

500

115581

422

x50

AN3C4A

Purchased

No

200

Each

1,230.000

50

50



BOLT



21 11/03/21

Location

Loc Qty

Loc Code

ST350

1230

115300

25

115936

8

116075

997

116590

200

M116924

x22

M11700

x28

AN960C10L

NAS1149C0332

Purchased

No

200

Each

25.0000

50

50



washer



21 11/03/21

Location

Loc Qty

Loc Code

ST245

25

107534

25

M116304

x50

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Shop Packet Print

Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 65590

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-13

Manufactured No

200

Each

26.0000

1

1



Gasket



11/03/21

Location

Loc Qty

Loc Code

FP012

6

B66137

X1

61996

6

FP014

20

64070

20

D3566-5

Manufactured No

200

Each

13.0000

1

1



Gasket



11/03/21

Location

Loc Qty

Loc Code

FP

12

64789

12

FP015

1

B65528

X1

63574

1

D3566-1

Manufactured No

200

Each

6.0000

2

2



Gasket



11/03/21

Location

Loc Qty

Loc Code

FP015

6

57715

1

B66548

X2

63573

5

D3564-11

Manufactured No

200

Each

8.0000

1

1



Wearshoe



11/03/21

Location

Loc Qty

Loc Code

FP019

8

62236

8

B66554

X1

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Replacement Skidtube

Start Date: 1/21/2011



Required Date: 2/10/2011

Start Qty: 1.00



Required Qty: 1.00

D3564-13 Manufactured No 200 Each 16.0000 1 1
  xl 1/03/20
 Wearshoe

Location	Loc Qty	Loc Code
FP17	16	
59660	1	B66549
61828	3	
62229	12	

D3564-9 Manufactured No 200 Each 17.0000 1 1
  xl 1/03/20
 Wearshoe

Location	Loc Qty	Loc Code
FP	1	
55334	1	B65524
FP019	1	
61709	1	
FP19	15	
62238	15	

D3564-5 Manufactured No 200 Each 22.0000 1 1
  xl 1/03/20
 Wearshoe

Location	Loc Qty	Loc Code
FG	1	
34806	1	B66551
FP19	2	
57525	1	
58709	1	
FP-19	19	
63575	8	
65058	11	

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Parent Item Name: Replacement Skidtube

Start Date: 1/21/2011

Required Date: 2/10/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

739.0000

16

16



O-Ring, 205 Skidtube



ul 1/23/21

Location

Loc Qty

Loc Code

FP

43

55546

19

58191

12

59358

12

fpa

696

61762

696

x16

D2594-1

drab green

Manufactured No

200

Each

235.0000

16

16



Plug, 205 Skidtube



(x16) ul 1/23/21

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

52

58434

15

62893

37

B67088

x7

B67411

x9

W/O:		WORK ORDER CHANGES					
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DART**RELEASED**
07.06.28 #**DEO ATTACHED**

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

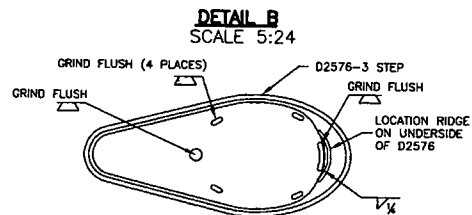
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

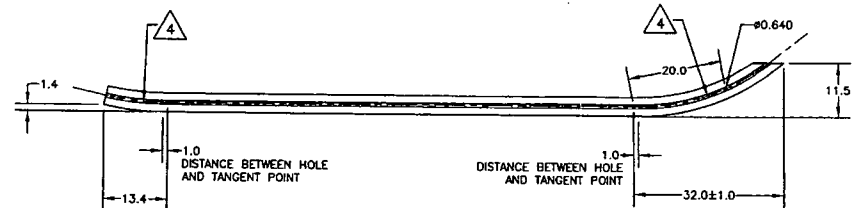
NOTE: Date & initial all entries

D2580-1 DRILLING DETAIL

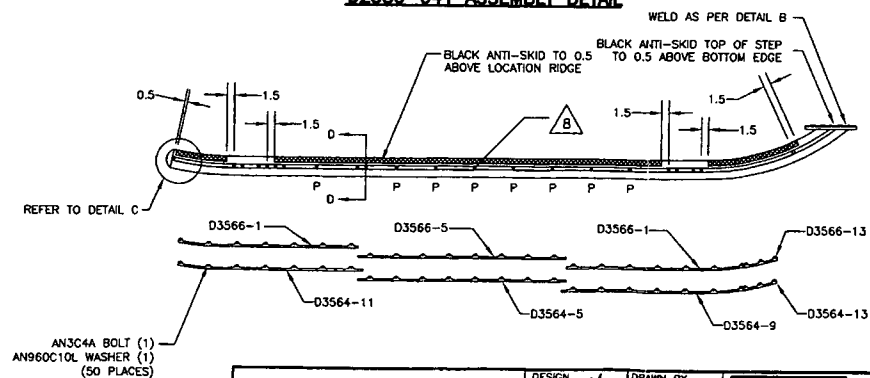


DEO ATTACHED

D2580-1 BENDING AND CUTTING DETAIL




D2580-041 ASSEMBLY DETAIL



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DESIGN <i>HH</i>	DRAWN BY <i>HH</i>	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D2580	REV. D
DATE 07.02.27		SCALE 1:24	SHEET 2 OF 3
		TITLE 205 SKIDTUBE ASSEMBLY	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

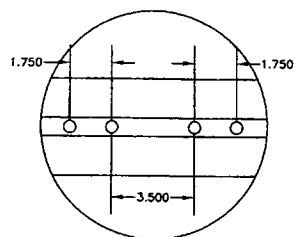
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

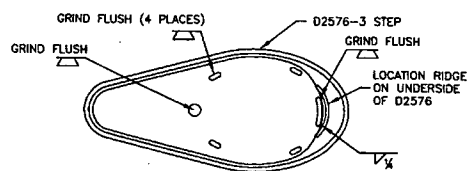
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL E
SCALE 5:24



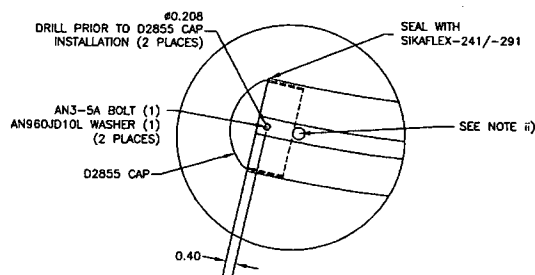
DETAIL F
SCALE 5:24



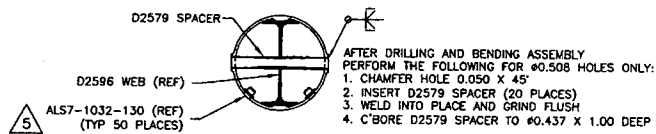
RELEASED
07-16-78

DEO ATTACHED

DETAIL G
SCALE 5:24



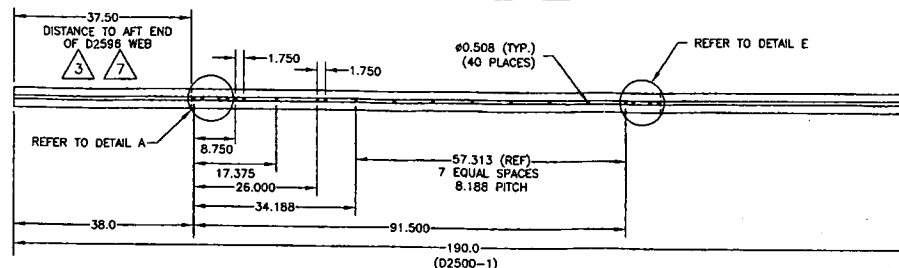
SECTION H-H
SCALE 5:24



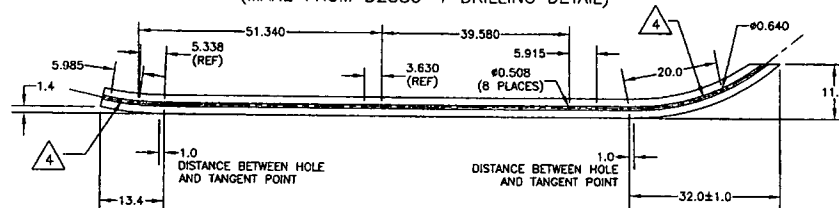
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

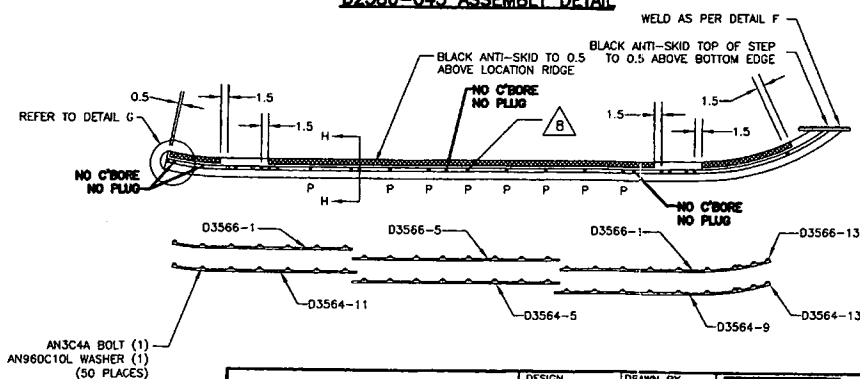
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED <i>RH</i>	APPROVED <i>RH</i>	DRAWING NO. D2580	HAVERSBURY, ONTARIO, CANADA
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	SHEET 3 OF 3
		SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>		DE APPR. <i>H</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

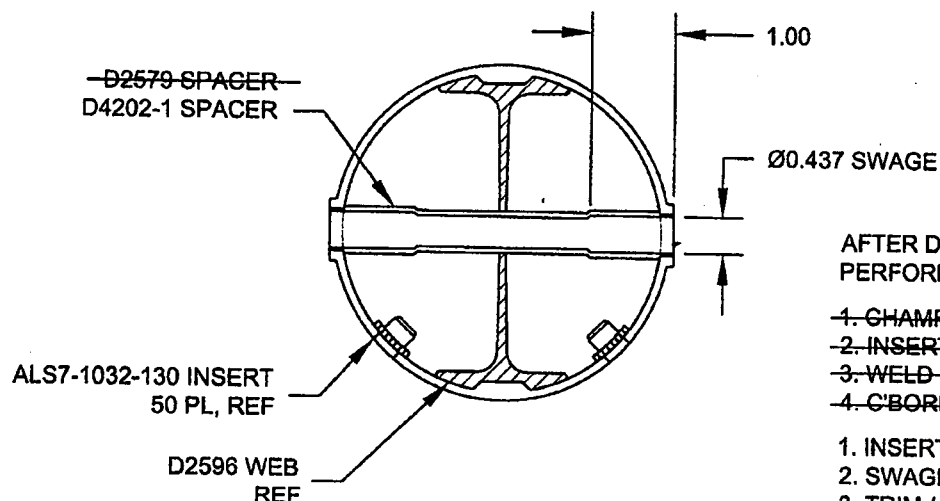
WAS

QTY -041	QTY -045	PART NUMBER	DESCRIPTION
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries